

Date: Tuesday, 5/16/2006 10:40:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB
 Job Number : 27146
 Estimate Number : 10482
 P.O. Number : NIA Part Number : D2923
 This Issue : 5/16/2006 S.O. No. : NIA Drawing Number : D2923 REV.A
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LANDING GEAR Drawing Revision : A
 Previous Run : 25870 Material : NIA
 Written By : SAG COMMENT Below Due Date : 6/4/2006 Qty: 4 Um: Each
 Checked & Approved By : 98 06-05-16
 Comment : Est. B 02.07.26 Updated Location RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26005108 Extrusion 'I Beam' thin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

D2600-5-108 Extrusion 'I Beam' thin

Batch: B2440

DM 06-05-25 (4)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut D2600-5 Extrusion to length as per Dwg D2923.

Deburr ends

DM 06-05-25 (4)

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Drill pilot holes in web as per Dwg D2923 using drill jig DT8481

2- Open holes to finish size as per Dwg D2923.

3- Deburr

DM 06-05-29 (4)

DM 06-05-26 (4)

DM 06-05-29 (4)

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DE 06-05-29 (4)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BT 06-05-29

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/05/30

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/16/2006 10:40:54 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 27146

Part Number: D2923

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SE 06-05-29 (4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

Pm' 06-05-29 (4)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/05/30 (4)

Job Completion



U 06-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A.	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

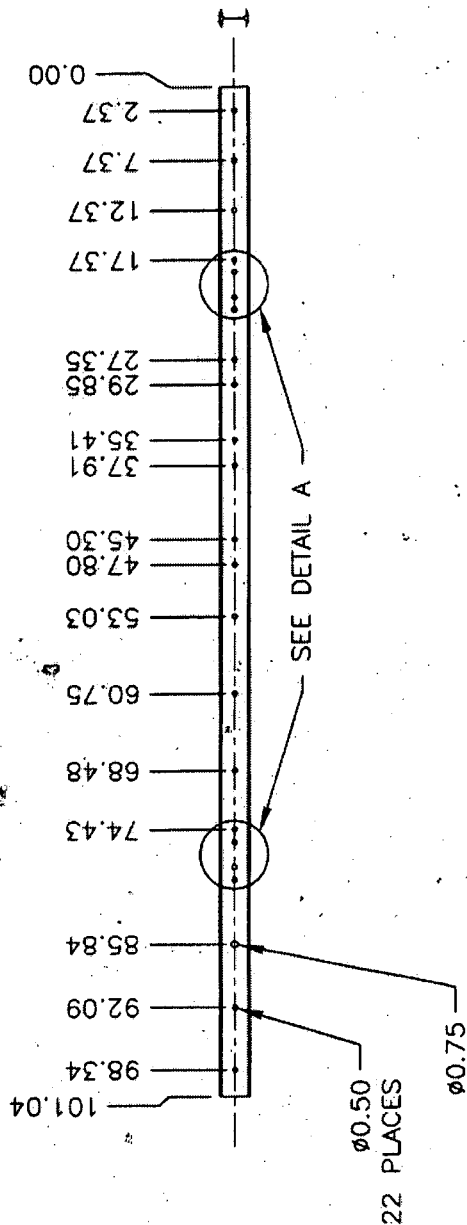
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

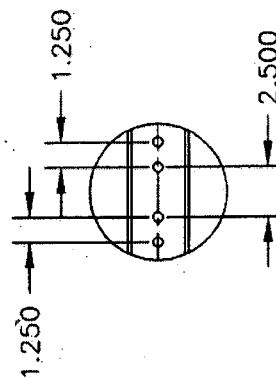


DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED 	APPROVED 	DRAWING NO. D2923	REV. A SHEET 1 OF 1
DATE 99.10.14		TITLE WEB	SCALE 1:18
A	99.10.14	NEW ISSUE	

RELEASED
00.05.11



DETAIL A
SCALE 1:9



MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHORT COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 27146

